

Ship March 19

Dart Aerospace Ltd.

Date: Monday, 3/12/2007 10:57:48 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 31162
Estimate Number : 12369
P.O. Number : *NA*
This Issue : 3/12/2007 S.O. No. : *NA*
Prsht Rev. : NC
First Issue : 3/12/2007 Type : LANDING GEAR
Previous Run : 29528

Drawing Name : ARMOR SHIELD

Part Number : D412664203A
Drawing Number : DSI9326
Project Number : N/A
Drawing Revision : A
Material : *N/A*
Due Date : 3/19/2007

Qty: 1 Um: Each

Written By : *[Signature]*
Checked & Approved By : *[Signature]* 07.03.12
Comment : Est Rev: A New Issue 06-04-19 JLM
est rev. B Per ECN 886 06.12.08 EC

Additional Product

Job Number:



DART			
TRANSPORT CANADA APPROVAL 4-09-09			
P/N	D412-664-203	CHG	CHG005
DESC	Crosstube Aft High	STC	SH01-9
LOT	B27181	STC	SR01298NY
MODEL	Bell 412	STC	
MADE IN CANADA			

Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: Photocopy bluefile & type labels per PPP D412-664-203A CHG005

KS 07-03-12

2.0 D412664203 Crosstube Aft High

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Fwd Crosstube
Batch: *27181* *ml 07/03/14*

3.0 HAND FINISHING1 HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1
1-Remove tube from packaging

2-Apply Armor sheild as per DSI 9326

A/R Armor Sheild Batch: *M1012414 102084* *ml 07 03 16*

4.0 QC14 Inspect Spray Paint



Comment: Inspect Spray Paint

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-664-203A

Location:

PPP Rev: *BPA01* *07/3/19* *(1)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ~~HP~~ Date: 07/03/19

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

~~07/03/19~~

Job Completion



U 07-03-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>J.J.</i>	APPROVED <i>#</i>	DRAWING NO. DSI 9326	REV. A SHEET 1 OF 1
DATE 06.02.14		TITLE ARMOR SHIELD	SCALE NTS
A	06.02.14	NEW ISSUE	

DART SERVICE INSTRUCTION

To further protect Dart crosstubes from mechanical damage in service, they may be treated with "Armor Shield" surface treatment.

INSTALLATION	CANADIAN STC	FAA STC
D205-596-101/-103/-105/-107	SH03-6	SR01742NY
D212-864-101/-201	SH01-9	SR01298NY
D412-664-203		
D206-667-101/-103/-201/-203	SH01-5	SR01304NY
D407-667-105/-205		
D058-676-101/-201	N/A	SR01018SE

To designate crosstubes with 'Armor Shield' add 'A' to the Part Number. For example, D206-667-101A is a D206-667-101 crosstube coated with Armor Shield. It is acceptable to apply the Armor Shield in regions shown in Figure 1 only. It is **NOT** acceptable to apply Armor Shield in the cuff and support/clamp regions.

1.0 To apply Armor Shield

- 1) Ensure the crosstube is appropriately finished in accordance with the relevant manufacturing drawing or instruction for Continued Airworthiness (ICA).
- 2) Mask areas around supports and cuffs per Figure 1. Abrade paint finish in areas requiring protection using 320 grit sandpaper.
- 3) Clean/degrease surface of crosstube using Methyl Ethyl Ketone (MEK), 4105S Wash'n'Wipe Degreaser, or equivalent and wipe the surface to clean the entire area.
- 4) Apply 3 coats of Proform PF 746 or PF 746-1 to surface (apply additional coats when surface is dry, but not fully cured).
- 5) Allow 5 hours for coating to dry.
- 6) Apply 2 coats of Imron 500s Polyurethane Enamel clear + Dupont Imron Polyurethane Enamel Activator 192S (mix 3:1). Mix 15 minutes prior to application and allow 15 minutes before applying additional coats.

2.0 Armor Shield removal/re-application

To remove the Armor Shield coating or if damage to the coating and/or crosstube is observed during inspection.

- 1) Remove Armor Shield from the affected area using 80 grit sandpaper. To remove Armor Shield from larger areas, bead blasting has been determined to be the most effective technique.
- 2) Repair mechanical damage (within limits) to the crosstube and touch up finish in accordance with the relevant ICA.
- 3) Apply Armor Shield in accordance with Section 1.0 of these instructions.

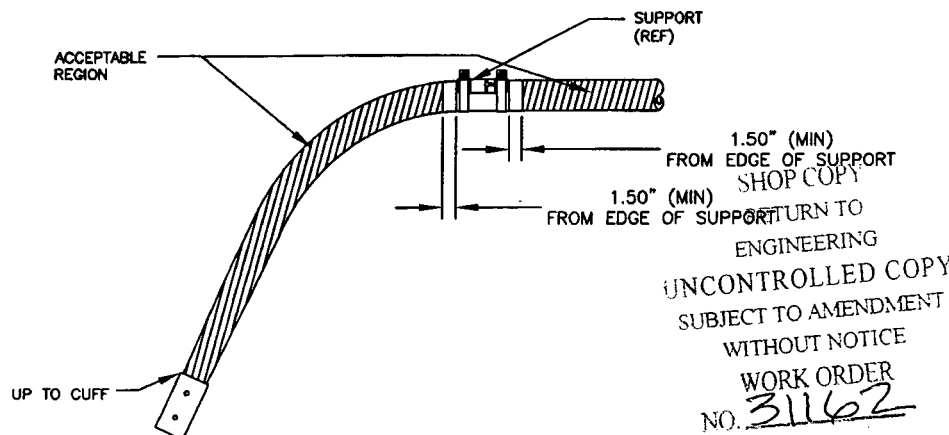


FIGURE 1 - ACCEPTABLE REGIONS TO BE COATED WITH ARMOR SHIELD

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED	
BY:	<i>[Signature]</i> D. SHEPHERD (DE # 02)
DATE:	06.02.14
CERT. NO.:	SH03-6/SH01-9/SH01-5
ISSUE NO.:	3/3/3

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